

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008852**Date Inspected:** 07-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

CB4

FCAW welding of weld joint 003 located on CB201A.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234-B-U2-F.

5BE

FCAW welding of weld splice joint 169 located on SSD12A.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2234-B-U2-F.

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5BW

FCAW welding of weld splice joints 170, 171, 164 and 165 located on SSD11A.
Welder is identified as Mr. Cao Cai Jun (220064). ZPMC QC is identified as Li Jia.
The welding variables recorded by QC appeared to comply with WPS-B-T-2134.

FCAW welding of weld splice joints 172, 173, 166 and 167 located on FB021.
Welder is identified as Mr. Cao Cai Jun (220064). ZPMC QC is identified as Li Jia.
The welding variables recorded by QC appeared to comply with WPS-B-T-2134.

3BW

This QA Inspector performed Magnetic Particle Testing (MT) verification of repair areas on side plate t stiffener hold back weld located on the counter weight side of segment at panel point 23. This QA Inspector observed two transverse and one longitudinal indication. This area was previously MT tested and accepted by Quality Control Department. This QA Inspector issued an incident report on the above noted MT rejection.

1AAE & 1AE

This QA Inspector was in progress of performing MT inspection of weld splice 1AAE to 1AE with QA Inspector Dan Hernandez. During the course of inspection, ZPMC production personnel unplugged the power, taking Caltrans electrical cords, attempted to coat the weld with UT couplant, shouting, and making physical contact with Caltrans QA Inspectors. This QA Inspector and QA Inspector Mr. Hernandez left the area to contact Caltrans supervisory (Mark Miller), ZPMC QA Wang Lu and ABF Quality Assurance Manager (Steve Lawton). Mr. Lawton later advised Mr. Wang Lu of the Contract requirement to provide QA with access at all times. Upon further discussion between ZPMC and ABF, Caltrans QA received permission to continue both MT and UT.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
